

Date: Monday, 2/11/2008 2:12:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM  
 Job Number : 37337  
 Estimate Number : 11047  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 37243  
 Part Number : D28441  
 Drawing Number : D2844 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 2/18/2008 Qty: 40 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: B 00.11.01 Removed P/O for Powder Coat - in house  
 processEC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TRO500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.9941 f(s)/Unit Total : 79.7622 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using 22.314

Jig DT 8012

Batch M107146

JB 08/03/10

(40)

2.0 BRAKE NC NC BRAKE



Comment: BAND SAW

Form per Dwg D2844 using brake and bending Jig DT 8238-B

Debur

→ 08/03/10

FF 08-03-12

(40)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/13

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

08-03-17

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/03/17

(40X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 08/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:12:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 37337

Part Number: D28441

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



*JS 08-03-18*

Comment: DIMENSIONAL CHECK

ensure parts are still as per dwg D2844

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *st265*

*JS 08/03/18*

*(4)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*(4)*

Comment: FINAL INSPECTION/W/O RELEASE

*HD 08/03/19*

Job Completion



*2008/3/18 (40)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

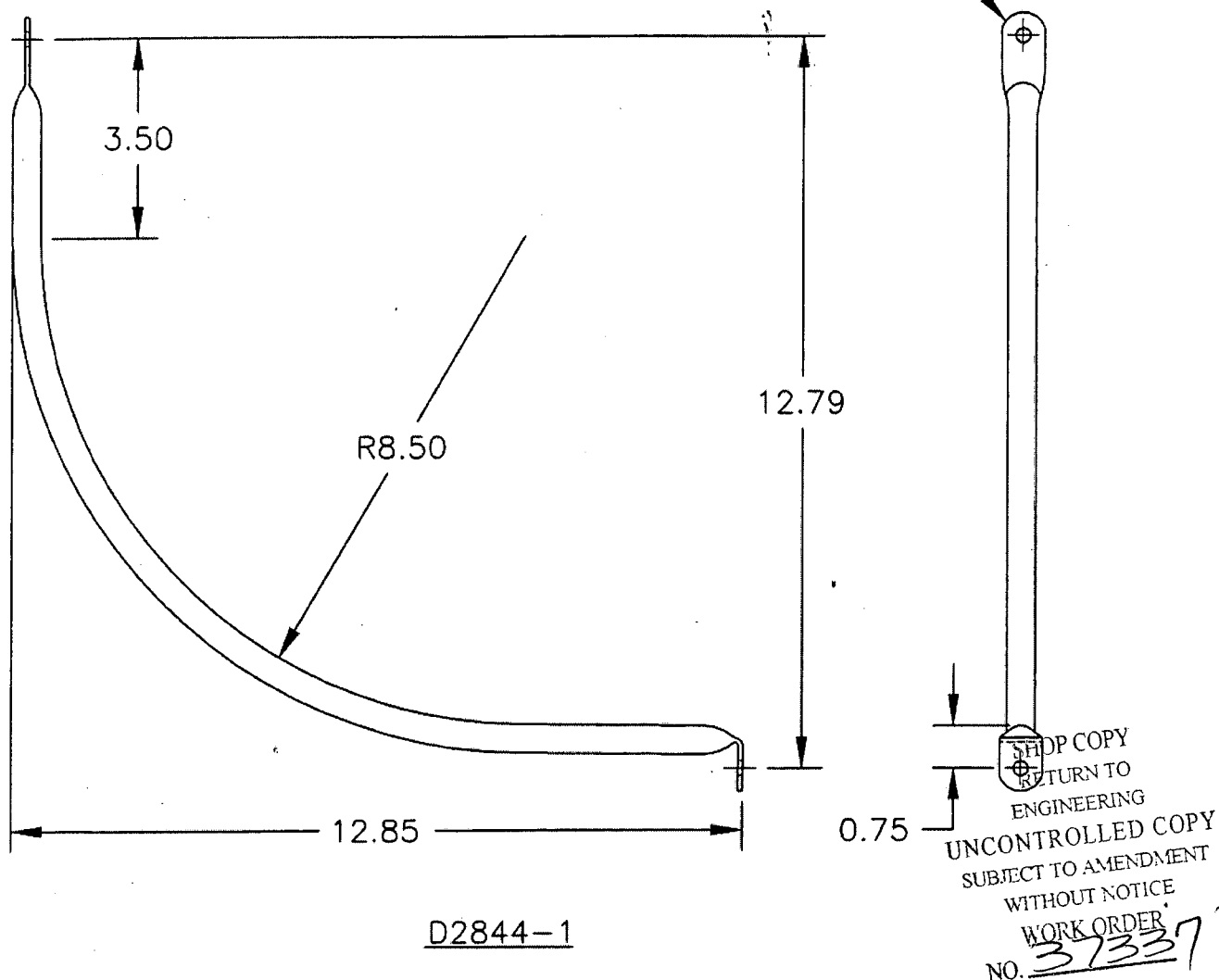
**NOTE:** Date & initial all entries



|                       |                       |   |                        |
|-----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>KE</i>   | DRAWN BY<br><i>KE</i> | DART AEROSPACE USA, INC.<br>FAIRCHILD INTERNATIONAL AIRPORT, WA |                        |
| CHECKED<br><i>DAH</i> | APPROVED<br><i>Q</i>  | DRAWING NO.<br>D2844  | REV. A<br>SHEET 1 OF 2 |
| DATE<br>98.10.14      |                       | TITLE<br>ARM  | SCALE<br>1:3           |
| A                     | 98.10.14              | NEW ISSUE   |                        |

RELEASED  
98.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



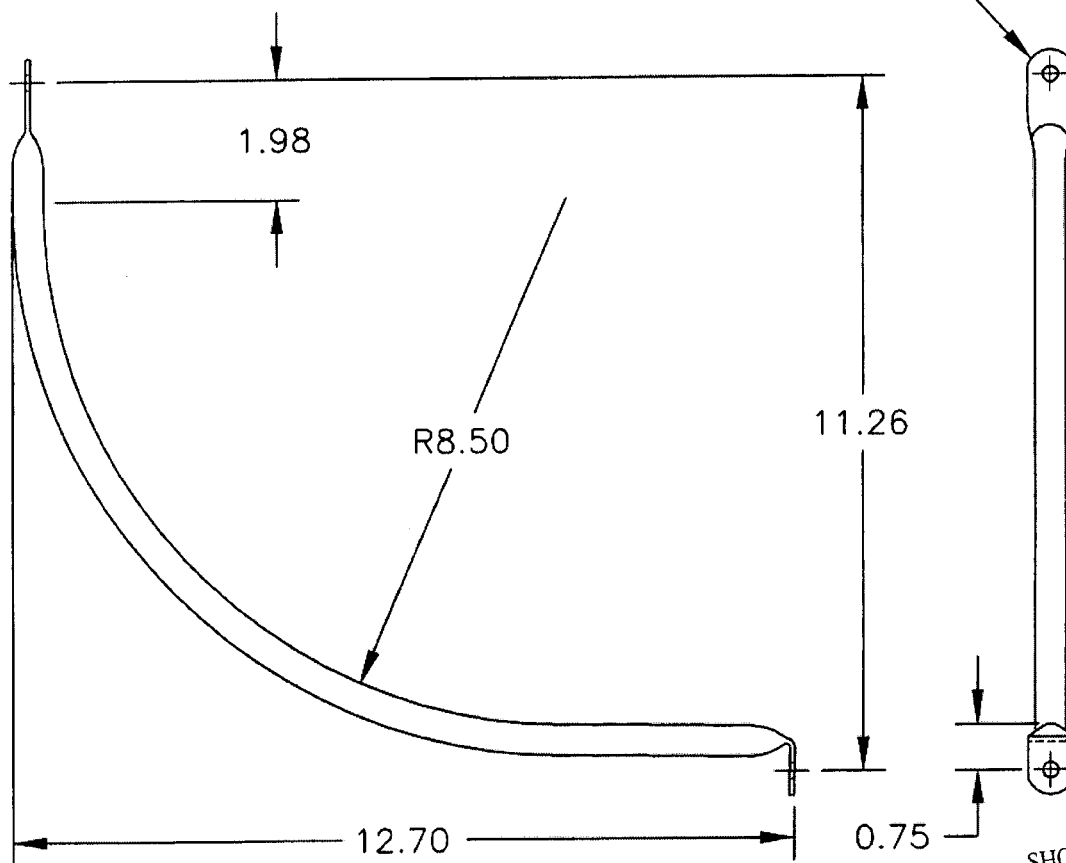
MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3



|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>KE</i>  | DRAWN BY<br><i>KE</i>          | DART AEROSPACE USA, INC.<br>FAIRCHILD INTERNATIONAL AIRPORT, WA |                        |
| CHECKED<br><i>DH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2844  | REV. A<br>SHEET 2 OF 2 |
| DATE<br>98.10.14     |                                | TITLE<br>ARM  | SCALE<br>1:3           |

RELEASED  
14.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37337

MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3